

Thursday, 7/19/2007 2:20:20 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PIN
 Job Number : 33628
 Estimate Number : 12672
 P.O. Number : N/A Part Number : D31471
 This Issue : 7/19/2007 S.O. No. : N/A Drawing Number : D3147 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 31578 Material : N/A
 Due Date : 7/20/2007 Qty: 2 Um: Each
 Written By : [Signature]
 Checked & Approved By : 07.07.19
 Comment : Est Rev A New Issue 07-01-26 JLM
 Est Rev:B Now on Cnc 07-05-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0187 303 Round Bar 0.187"



Comment: Qty.: 0.2363 f(s)/Unit Total : 0.4725 f(s)

303 Round Bar 0.187"

Batch: M103435

DIP 07/07/21 (2)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA691 & DWG D3147 ,

FOLIO REV: AA

DWG REV: C

2-DEBURR AS REQUIRED

DIP 07/07/21 (2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 07/07/21 (2)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA691 Rev: C - & Dwg D3147 Rev: C

2-Deburr per dwg D3443

07/07 07.23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:20:20 PM
User: Kim Johnston

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Drawing Name: PIN

Job Number: 33628

Part Number: D31471

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



7/19/07-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



7/19/07-23

Comment: SECOND CHECK

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/17/23 (2x) 50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

7/19/07-23

Job Completion



7/19/07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

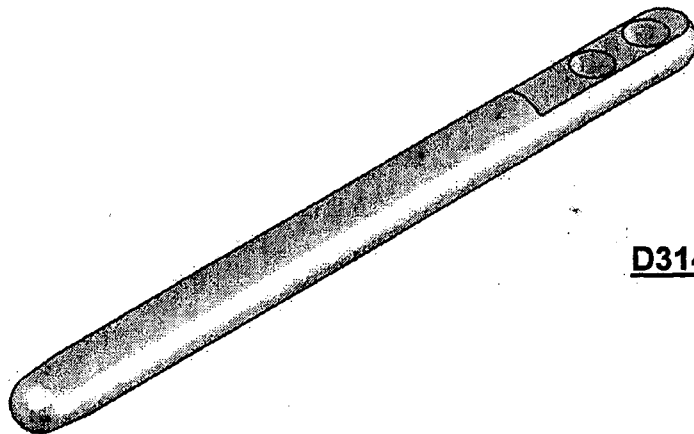
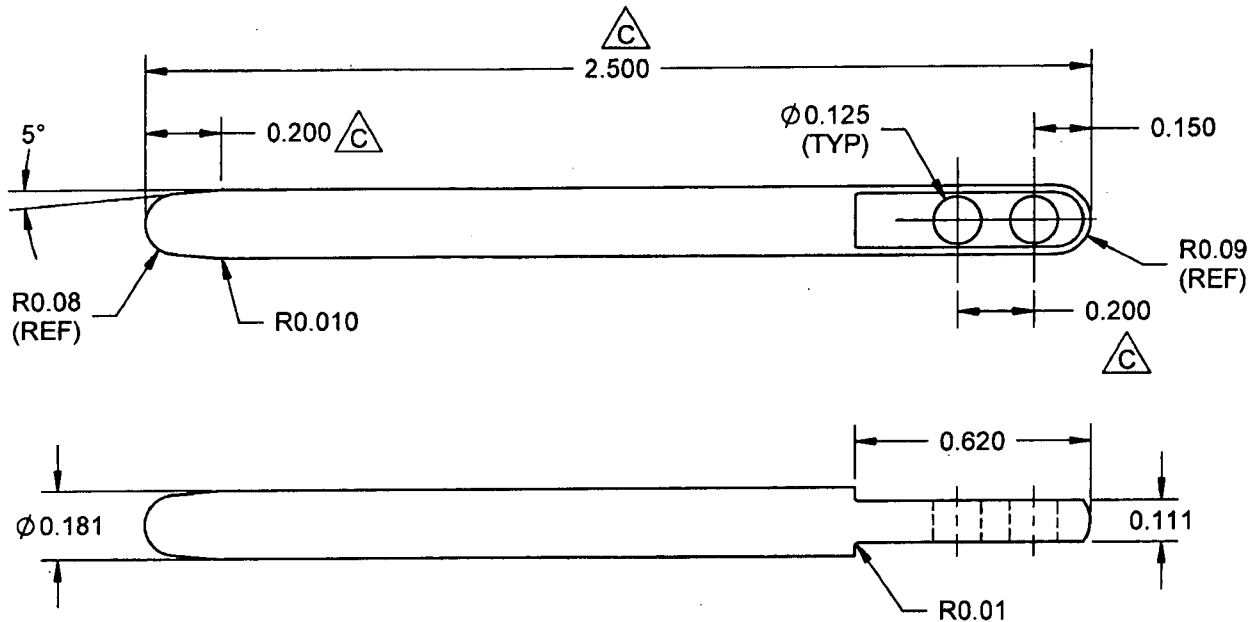
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED JH	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04		TITLE PIN	SCALE 2:1
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND Ø0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	

**D3147-1 PIN****RELEASED**

07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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